

Date: Friday, 01/05/2009 11:20:08 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE SOCKET
Job Number :	47652		
Estimate Number :	11210		
P.O. Number :		Part Number :	D333017
This Issue :	01/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3330 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	44367	Drawing Revision :	D
	Type :	Material :	
	MACHINED PARTS	Due Date :	18/05/2009
Written By :		Qty:	10
Checked & Approved By :	<u>JLD 09-05-09</u>	Um:	Each
Comment :	Est: A 05.01.13 New issue KJ/JLM est B 07.05.14 rev C dwg EC est D 07.12.12 Rev D dwg EC verified by:DD Est Rev:E Now on Doosan Lathe 08-06-02 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1025TR1125W125	tound tubing 1.125 x .125w
-----	-----------------	----------------------------



Comment: Qty: 0.2187 f(s)/Unit Total : 2.1872 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 1.125" dia tubing, 0.125" wall
 (M1025TR0.875W.125)

Batch: M16439 ml 09/09/09 (11)

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: DOOSAN LATHE

Turn as per Folio FA490 and Dwg D3330

ml 09/05/09 (11)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/05/09 (11)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 09/05/10 (11)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl L.

SS 09/05/11 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:20:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE SOCKET

Job Number: 47652

Part Number: D333017

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____



Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

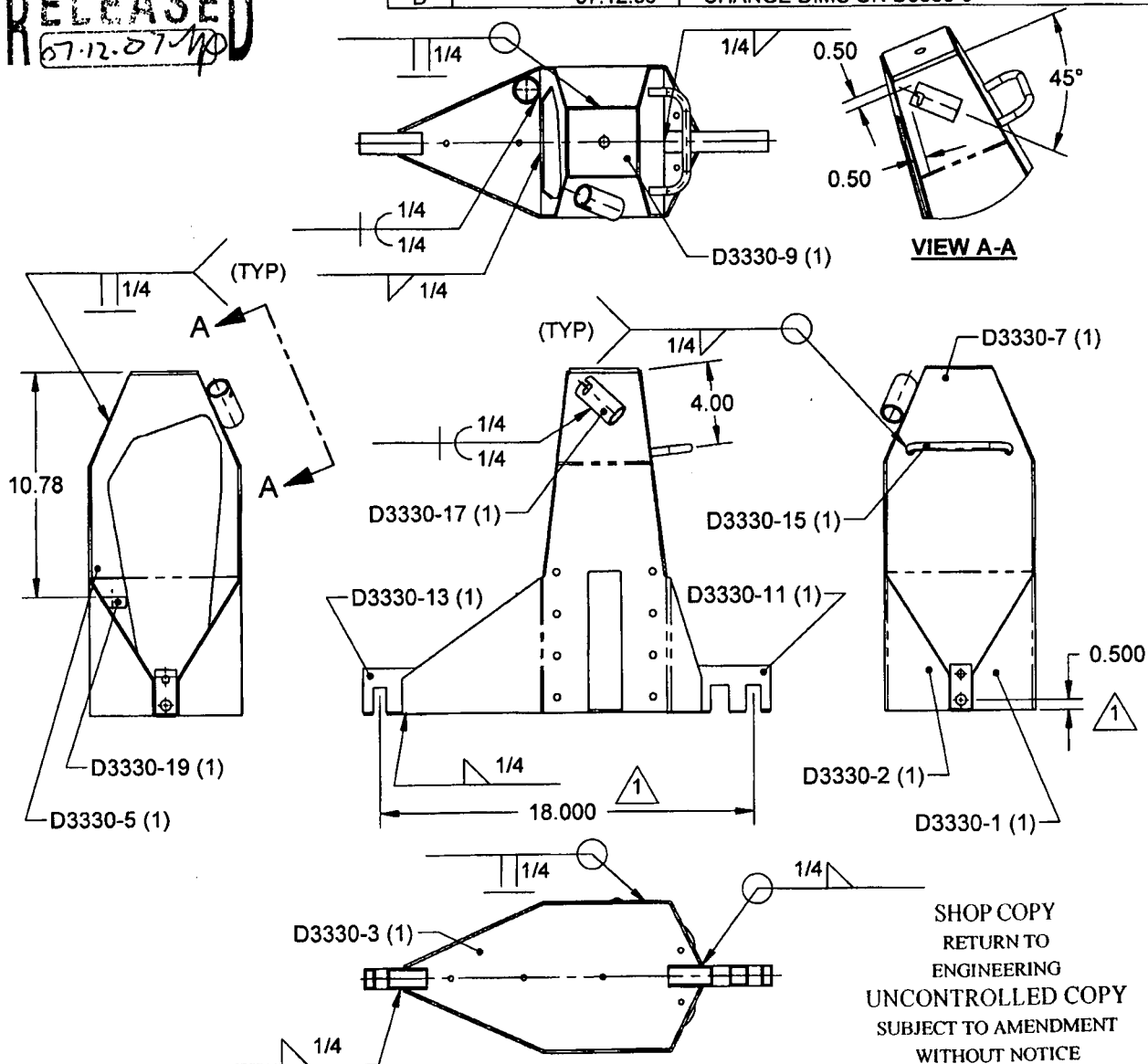
☒ **First Article** ☐ **Prototype**[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/05/09	Date:	09/05/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.03.04	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.03.23	Dimensions update per Rev C	KJ/JLM	

DART**RELEASED**
07.12.07

DESIGN <i>B</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>L</i>	APPROVED <i>W</i>	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT	SCALE 1:8	
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

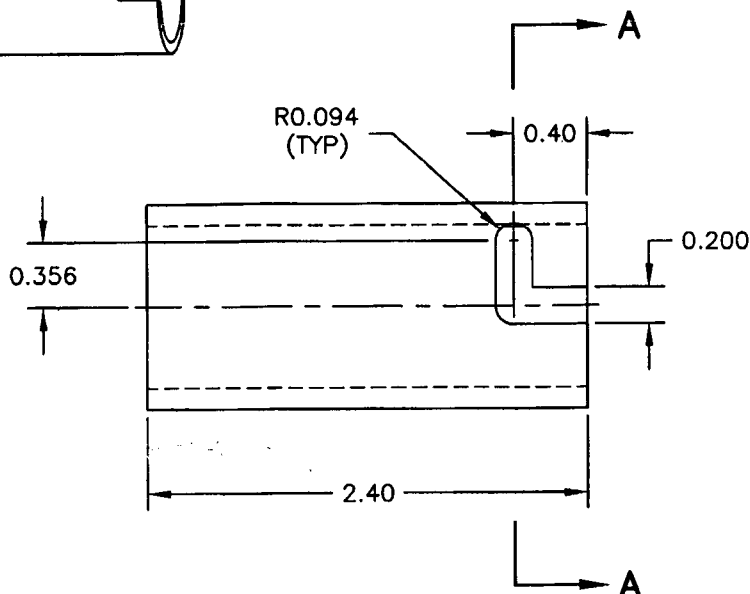
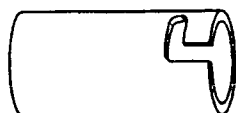
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47052

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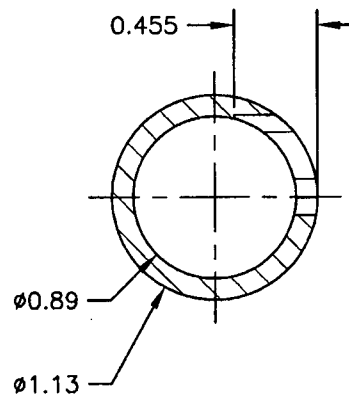
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CHECKED <i>B</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. D SHEET 8 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:1

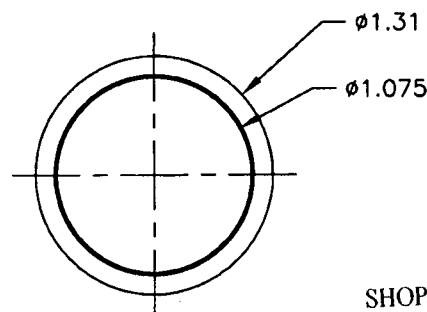
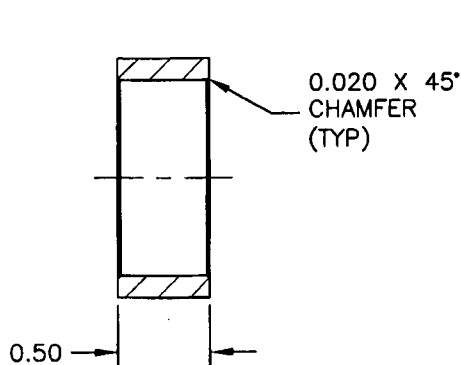


RELEASED
07.12.07 *MB*



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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